

Split
Work Order ID **158814** -1

158814

Page 1

Friday, March 31, 2017 7:15:41 PM

Item ID: D5354-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: R66 Fwd Clamp Assembly, LH
 Start Date: 4/4/2017 Start Qty: ~~3.00~~ ***3*** Cust Item ID:
 Required Date: 4/6/2017 Req'd Qty: 3.00 ***3*** Customer:
 Reference: SCHEDULED
 Approvals: Process Plan: _____ Date: MAR 31 2017 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5354	C

100	BAND SAW	0.00							DAS 08 9-09
100									
Bandsaw	Memo	0.02							
Jeaspa Bandsaw	Cut Blanks at 4.250"								

D.P. 17-04-08

110	HAAS CNC VERTICAL MACHINING #1	1.26							DAS 08 9-09
110									
HAAS 5AXIS	Memo	3.80							
HAAS CNC vertical machine #5	1-Machine per folio FB436 (D5354-1) DWG REV: <u>C</u> FOLIO REV: <u>AA</u>								

D.P. 17-04-08

2- deburr and break all sharp edge as per dwg

Friday, March 31, 2017 7:15:41 PM

Page 2

Stop *NR2*

Quality Control

Quality Control

Certification of Comformity is required.

Work Order ID 158814

Friday, March 31, 2017 7:15:41 PM

158814

Page 3

Item ID: D5354-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: R66 Fwd Clamp Assembly, LH
Start Date: 4/4/2017 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 4/6/2017 Req'd Qty: 3.00 ***3*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.06							
Packaging	Certification of Conformity is required.								
155	QC5- Inspect part completeness to step on W/O	0.00							
155									
QC	Memo	0.06							
Quality Control									

3x 8017-5-11

3

DAS
38
9-89

MAY 11 2017

Friday, March 31, 2017 7:15:41 PM

158814

Page 4

N900040100

Setup Start *NS1*

Stop *NS2*

3

Cust Item ID:

Start Date: 4/4/2017 **Start Qty:** 3.00

Required Date: 4/6/2017 **Req'd Qty:** 3.00

3

Customer:

Reference: SCHEDULED

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]DA
19
2-81

DAS
38
9-89

MAY 18 2017

Friday, March 31, 2017 7:15:41 PM

Page 5

DAS
21
9-89

MAY 18 2017

Picklist Print

Friday, March 31, 2017 7:15:40 PM

Page 1

Work Order ID: 158814

158814

Parent Item: D5354-041

D5354-041

Parent Item Name: R66 Fwd Clamp Assembly, LH

Start Date: 4/4/2017

Required Date: 4/6/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 16.01.05 NEW ISSUE DD VERF:JLM IPP
REV:B 16.01.26 REV.A DWG DD VERF:JLM IPP REV:C
16/07/08 Per rev.B dwg. JFS Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B1.250X04.50
0

Purchased

No

100

f

8.0764

0.354

1.117895

M6061T6B1 250X04 500

**

17-04-05

6061-T6 Bar 1.25 X 4.50

Location

Loc Qty

Loc Code

MAT004

8.0764

m133038

0.3014

→ m134776

7.775

*1.075***

D5316-1

Manufactured

No

160

Each

9.0000

1

3

D5316-1

**

MAY 17 2017

DAS
19
9-89

T-Bolt Strap

Location

Loc Qty

Loc Code

ST163

9

155066

9

155235

1

160

Each

0.0000

2

6

D5351-1

Manufactured

No

D5351-1

**

MAY 17 2017

DAS
19
9-89

T-Bolt Spacer

158932

2

Picklist Print

Friday, March 31, 2017 7:15:40 PM

Page 2

Work Order ID: 158814

158814

Parent Item: D5354-041

D5354-041

Parent Item Name: R66 Fwd Clamp Assembly, LH

Start Date: 4/4/2017

Required Date: 4/6/2017

Start Qty: 3.00

Required Qty: 3.00

MS21043-3 Purchased No 160 Each 936.0000 2 6 **** MAY 23 2017 DAS 19 9-89**

MS21043-3

Nut

Location	Loc Qty	Loc Code
FG	80	
103691	80	
FP001	203	
m130673	11	
m136182	192	
GA	215	
m133090	27	
m136182	188	(2)
ST302	369	
m136986	369	
ST304	69	
m131340	69	

NAS1149D0332J

Purchased

No

160 Each 1,682.000 2 6

MAY 23 2017

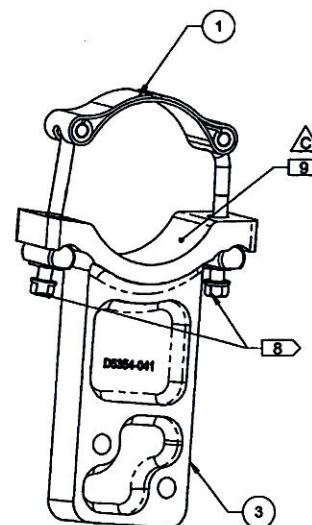
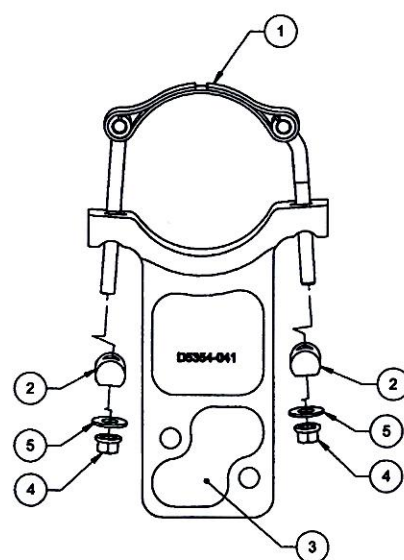
DAS 19 9-89

NAS1149D0332J

Washer

Location	Loc Qty	Loc Code
FP	28	
m136015	28	
GA	522	
m136643	522	(2)
ST260a	1000	
m137075	1000	
ST264	132	
m136015	132	

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5354-041	R66 FWD CLAMP ASSY, LH
1	1	D5316-1	T-BOLT STRAP
2	2	D5351-1	T-BOLT SPACER
3	1	D5354-1	SUPPORT, LH
4	2	MS21043-3	NUT, SELF-LOCKING
5	2	NAS1149D0332J	WASHER
6	A/R	PROSEAL 890	SEALANT



D5354-041 R66 FWD CLAMP ASSY, LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: AS SHOWN ON D5354-1
- 7) WEIGHT: 0.37 lbs
- 8) SECURE NUTS WITH 1-2 THREAD AS SHOWN
- 9) APPLY AN EVEN LAYER OF PROSEAL 890 (0.02" - 0.03" THICK) ON INSIDE SURFACE

C	ADDED ENGRAVING AND REVISE NOTE 8 AND LOCATION OF PROSEAL (ZN A8-1, C3-1, A8-2 C3-2, A8-3, C2-3, C7-3, A8-4, B2-4, C8-4)	RF	17.02.09
B	REDESIGN -1/-041, ADD -2/-042, REMOVE -043 (ZN A5-1, A5-2, A5-3, A5-4); ADD NOTE 9 (ZN A8-1, A8-2)	RF	16.05.24
A	NEW ISSUE	RF	15.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	JFS		
APPROVED	HS		
DE APPR.	DS		
DATE	17.02.09		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

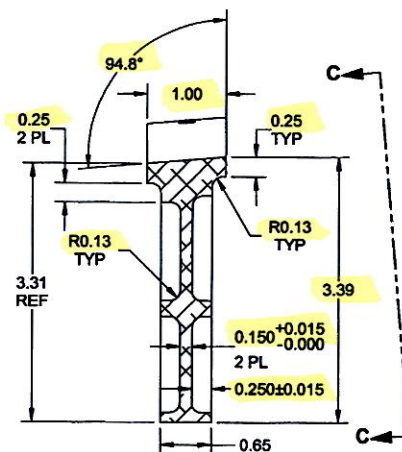
DRAWING NO. **D5354** REV. C
SHEET 1 OF 4

TITLE **R66 FWD CLAMP ASSEMBLY** SCALE NTS

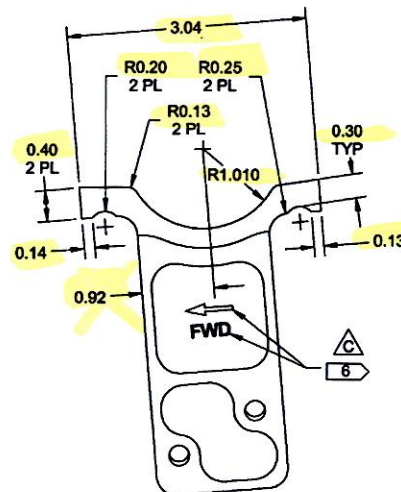
COPYRIGHT © 2015 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

RELEASED
2017-03-22
17-535

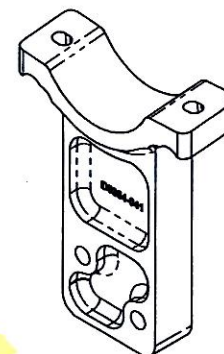
APPROVED



SECTION A-A



VIEW C- C



D5354-1 SUPPORT, LH

NOTES:

- 1) MATERIAL: 6051-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M0081T68
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH ASSEMBLY P/N, FWD & ARROW PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.29 lbs
- 8) UNDEFINED FEATURES CONTROLLED BY CAD FILE D5354-1 REV. C.SLDPRT

RELEASED
2017-03-22

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JFS	D5354	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66 FWD CLAMP ASSEMBLY	NTS
DATE	17.02.09 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN CONSENT OF DART AEROSPACE LTD.		

DART AEROSPACE LTD		Work Order: 158814
Description: SUPPORT, LH		Part Number: D5354-1
Inspection Dwg: D5354 Rev: C		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.279	+/-0.010	0.276	✓		Vern	GA-13
0.20	+/-0.030	0.199	✓		"	"
φ0.204	+0.005/-0.001	φ0.204	✓		"	"
0.50	+/-0.030	0.497	✓		"	"
R0.27	+/-0.030	R0.266	✓		R-6	ref.
φ0.257	+0.006/-0.001	φ0.260	✓		Vern	GA-13
1.28	+/-0.030	1.275	✓		"	"
0.13	+/-0.030	0.124	✓		Mic	GA-03
R0.25	+/-0.030	R0.250	✓		R-6	ref.
1.000	+/-0.005	1.000	✓		H-6	31006
1.67	+/-0.030	1.669	✓		Vern	GA-13
0.31	+/-0.030	0.310	✓		"	"
0.50	+/-0.030	0.499	✓		"	"
0.500	+/-0.005	0.499	✓		H-6	31006
0.15	+/-0.030	0.150	✓		Vern	GA-13
0.13	+/-0.030	0.125	✓		Mic	GA-03
R0.30	+/-0.030	R0.297	✓		R-6	ref.
R0.13	+/-0.030	R0.125	✓		"	"
0.25	+/-0.030	0.238	✓		H-6	31006
94.8°	+/- 1/2°	94.8°	✓		Angle M.	CNC-17
1.00	+/-0.030	0.998	✓		Vern	GA-13
0.25	+/-0.030	0.254	✓		"	"
R0.13	+/-0.030	R0.125	✓		R-6	ref.
3.39	+/-0.030	3.394	✓		H-6	31006
0.150	+0.005/-0.000	0.155	✓		Mic	118-120
0.250	+/-0.015	0.2475	✓		D-6	GA-08
0.14	+/-0.030	0.140	✓		Vern	GA-13
0.40	+/-0.030	0.396	✓		"	"
3.04	+/-0.030	3.041	✓		"	"
R0.25	+/-0.030	R0.250	✓		R-6	ref.
R0.20	+/-0.030	R0.206	✓		"	"
R0.13	+/-0.030	R0.125	✓		"	"

Measured by: D.A. DAS 08 9-89	Checked by: 14 DAS 14 9-89	QC Inspector:
Date: 17-04-08	Date: 17/04/11	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36011

Purchase Order Date 4/19/2017

PO Print Date 4/25/2017

Page Number 3 of 5

Order From :

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

FCA - (Free Carrier)

Line Total: \$98.7

7 159347 D2348 WEARPLATE 5/5/2017 20.00 \$0.95 \$19.0
REV. C

Yes

5/5/2017

BLACK ANODIZE AS PER MIL-A-8625F TYPE 1 OR IB/IC/II/IIB CLASS 2

Line Total: \$19.0

8 158932 D5351-1 T-BOLT REV. A 5/5/2017 20.00 \$0.90 \$18.0
REV. C

Yes

5/5/2017

BLACK ANODIZE AS PER MIL-A-8625F TYPE 1 OR IB/IC/II/IIB CLASS 2

Line Total: \$18.0

9 158814 D5354-041 R66 CLAMP 5/5/2017 3.00 \$2.50 \$7.5
REV. C

Yes

5/5/2017

BLACK ANODIZE AS PER MIL-A-8625F TYPE 1 OR IB/IC/II/IIB CLASS 2

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

4/25/2017

617-5-11



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913270

Date: 05-May-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
ea	Breakaway Tip Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied) Job: 20958 PO: PO36011	Line: 4	
25 ea	Part: 646.3719 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied) Job: 20959 PO: PO36011	Rev: A Line: 5	
25 ea	Part: 646.3718 Custom Washer Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied) Job: 20960 PO: PO36011	Rev: A Line: 6	
20 ea	Part: D2348 Wearplate Black Anodize per MIL-A-8625F, Type II, Class 2 Job: 20961 PO: PO36011	Rev: C Line: 7	
20 ea	Part: D5351-1 T-Bolt Black Anodize per MIL-A-8625F, Type II, Class 2 Job: 20962 PO: PO36011	Rev: A Line: 8	
3 ea	Part: D5354-041 R66 Clamp Black Anodize per MIL-A-8625F, Type II, Class 2 Job: 20963 PO: PO36011	Rev: C Line: 9	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements.			
Made in Canada.			

DAS
38
9-89

807511



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913270

Date: 05-May-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
		OUR TRUCK
Quantity	Description	
	Date: <u>05/05/2017</u> Certified Signature: <u>[Signature]</u> Receiver Signature: <u>[Signature]</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.	